

Date: Wednesday, 08/10/2008 3:18:48 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: SLIDING DOOR BRACKET	
Job Number	: 42515				Part Number	: D36751	
Estimate Number	: 13275				Drawing Number	: D3675 REVA	
P.O. Number	:				Project Number	: N/A	
This Issue	: 08/10/2008 S.O. No. :				Drawing Revision	: A	
Prsht Rev.	: NC				Material	:	
First Issue	: / / Type : SMALL /MED FAB				Due Date	: 25/10/2008	
Previous Run	: 40347				Qty:	84	
Written By	:				Um:	22 Each	
Checked & Approved By	: <u>JL 08.10.08</u>						
Comment	: Est Rev:A new issue 08-04-21 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		Comment: Qty.: 0.1271 sf(s)/Unit Total : 9.1476 sf(s) 304 stainless steel 0.032" Sheet Batch: <u>109057</u> <u>HB 8-10-17</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3675 Dwg Rev: <u>A</u> <u>HB 8-10-17</u> Prog Rev: <u>A</u> <u>HB 8-10-17</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<u>HB 8-10-17</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<u>HB 8-10-17</u> <u>84</u> <u>Circled</u>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		<u>HB 8-10-17</u> <u>84</u> <u>84</u>
		Comment: NC BRAKE Form as per Dwg D3675
		<u>HB 08/10/27</u> <u>84</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 08/10/2008 3:18:48 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING DOOR BRACKET

Job Number: 42515

Part Number: D36751

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



excenter

8081027

(X84)

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



m 106442

84

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 9:20

OVEN TEMPERATURE: 320°

FINISH TIME: 9:50

fx 08/10/28

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



84

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 238A

8081028 84

10.0 QC21

FINAL INSPECTION/W/O RELEASE



84

Comment: FINAL INSPECTION/W/O RELEASE

08/10/29

Job Completion



08.10.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42515
Description: Sliding Door Bracket	Part Number:	D3675-1
Inspection Dwg: D3675	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	13	Audited by:	✓	Prototype Approval:	N/A
Date:	8-10-17	Date:	08/08/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.12	New Issue	KJ/DD	 

8 7 6 5 4 3 2 1

D

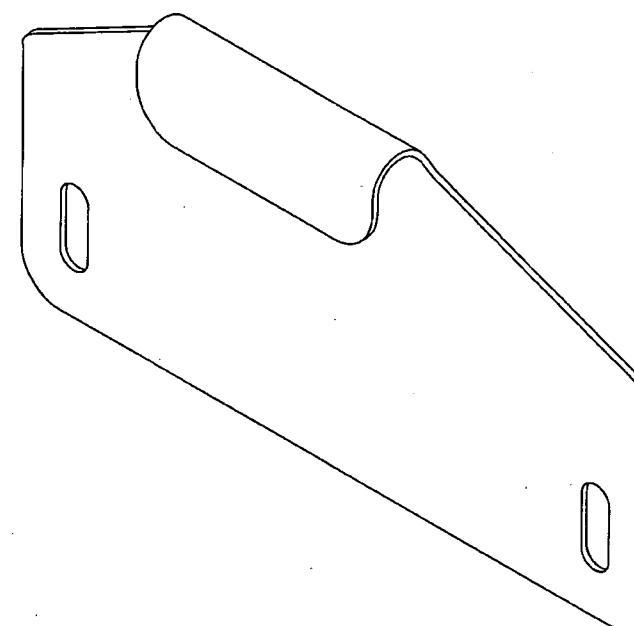
D

C

C

B

B



D3675-1 SLIDING DOOR BRACKET

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40515

RELEASED
08-08-26/11

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED)
REF. DART SPEC M304S
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.15 lbs
 - 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

A	NEW ISSUE		AJS	08.03.27
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	ASS			
CHECKED				
MFG. APPR.	AP			
APPROVED	MP	DRAWING NO. D3675 REV. A SHEET 1 OF 2		
DE APPR.	#			
DATE	08.03.27			

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1

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